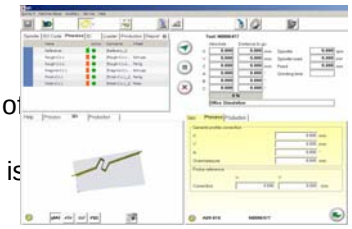
Application Data Sheet

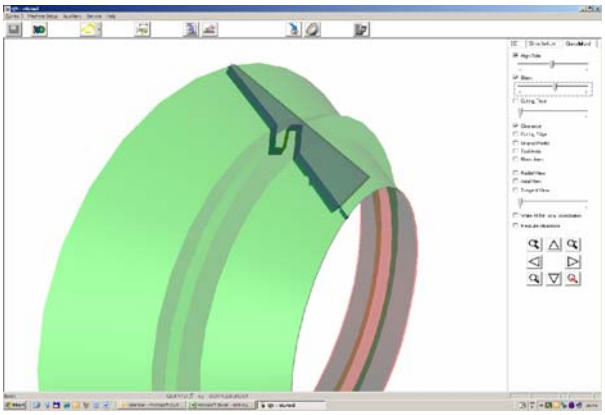
SCHNEEBERGER

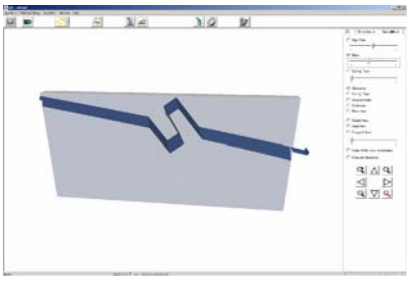
Woodinsert with seatangle

A09-010



Grinding Woodinserts with Quinto 5 uses as input the DXF of the woodprofile or, if not known, the profile of the distorted insert copied from the masterinsert. Usually the woodprofile is given, the reference dimensions of the millingcutter and the various orientation angles of the insert. With the 3D view the insert, the side and radial clearances can easily be verified. It is also possible to display the insert on the body of the cutter to verify the geometrical input. In addition a 3D simulation of the grinding process representing the wheelcontact on the clerance surface of the insert can be used. For standard inserts the wheel path is calculated automatically. The proposed paths and wheelpositions can be manually modified for all the pofileprocesses.





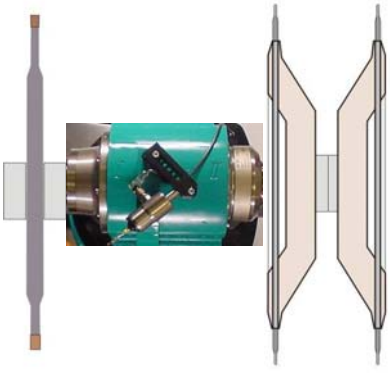
1. Cycletime for Production

Workpiece: Blanksize 45x40x2 Material CARBIDE					
Operations	 Probe	 Prf Rough	 Prf Pregr	 Prf fin	 Load/Unload
Feed [mm/Min]	2000	800	80	70	3000
Power [kW]		2	1	1	1
Cutting feed [m/s]		30	24	22	32
Used wheels		 1	 2	 3	
Grinding time [s]	41	186	43	46	15
Total cycle time	5 Min 31				

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	14F1 Ø300 D91 R1
2	14EE1 Ø300 D76 R0.8
3	14EE1 Ø300 D64 R0,4



1 3 2

3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIRIUS HPM
Control: Fanuc 160i
Accessories: STL6050 stack, Lasermarking,Cleaning

Coolant: Synthetic Oil, pressure 6 bar
Software: Quinto 5

Responsable engineer: KCM 7.12.09

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TECHNOLOGY FOR TOOLING